

Work Order ID 81038

March-07-12 7:42:26 AM

81038

Page 1

Item ID: D3827-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly (Inboard)
Start Date: 07/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 13/03/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/03/07 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3827	Rev A

100

100

Large Fab

Large Fab

Large Fab

Memo

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: M114509

7- grind weld flush

8- deburr if necessary

6/12/05/07
MAL6SAO 12-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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130 QC10- Inspect visual per QSI004- ground welds

0.00

130

QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: **WA**

0.00

150

Packaging

Memo

0.00

Packaging

6x **P** **PL1205.11**

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Work Order ID 81038***81038***

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Item ID: D3827-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rib Assembly (Inboard)

Stop ***NS2***

Start Date: 07/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/5/14 [Signature]
MCS 12/05/11

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 81038

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Parent Item: D3827-041

D3827-041

Parent Item Name: Rib Assembly (Inboard)

Start Date: 07/03/2012

Required Date: 13/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	357.0000	3	18			

D3759-1

Bushing

**

Location

Loc Qty

Loc Code

WA

203

79213

203

WA005

154

66489

1

74783

153

M304TS0.750W.065

Purchased

No

100

f

664.5479

8

50.52632

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

Location

Loc Qty

Loc Code

MAT017

616.890429

120267

116.890429

120633

500

MAT018

41

7636

41

WA007

0.5907428

116763

0.5907428

WA035

6.0667

118181

6.0667

M121170

50.52632

B79213

(18)

SAD

12-04-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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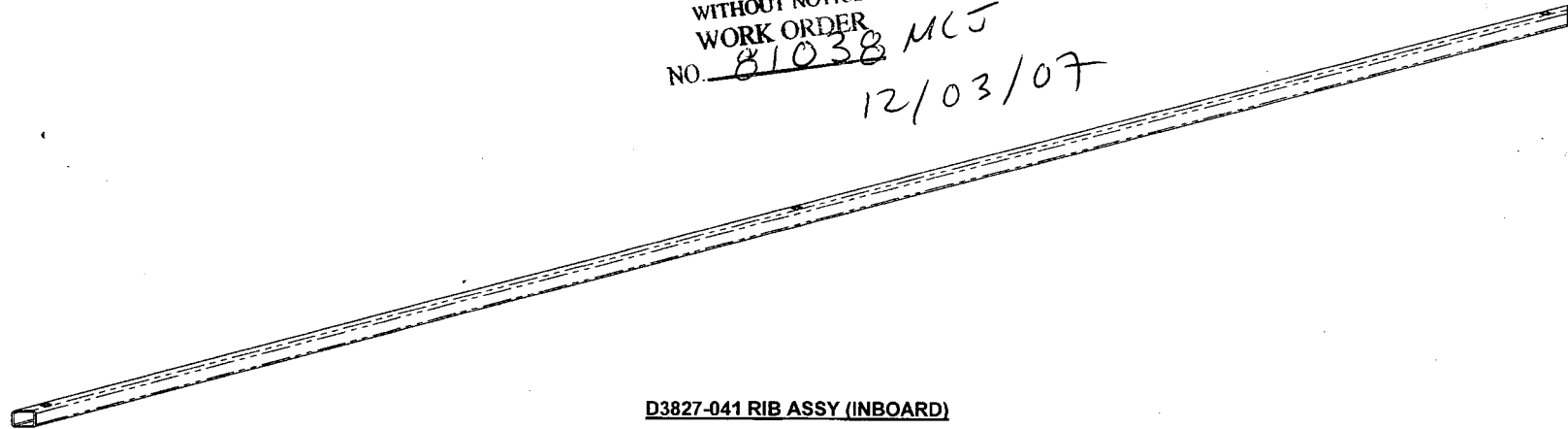
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81038 MCT
12/03/07



D3827-041 RIB ASSY (INBOARD)

RELEASED
08/14/13 MCT

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.59 lbs

A		NEW ISSUE		MB	08.09.23
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
CHECKED	ASS	DRAWING NO.	D3827	REV. A	SHEET 1 OF 3
MFG. APPR.		TITLE	RIB ASSY (INBOARD)	SCALE	NTS
APPROVED		DATE 08.09.23			
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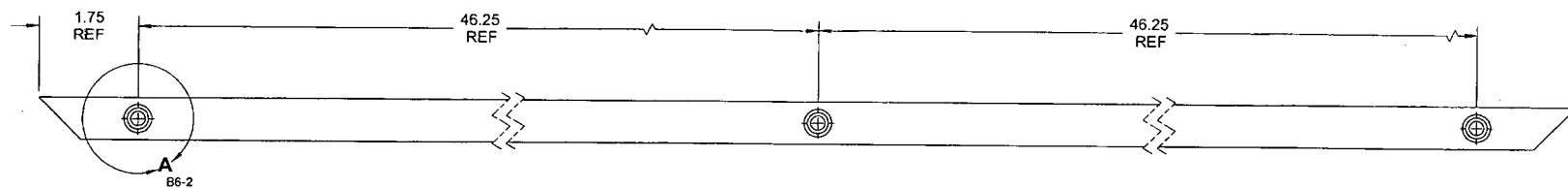
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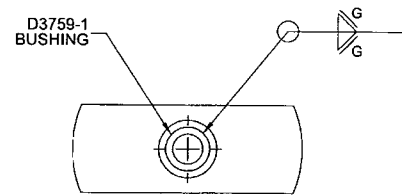
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D3827-041 RIB ASSY (INBOARD)



DETAIL A
SCALE 2X
C7-2
3 PL

RELEASED
08/11/18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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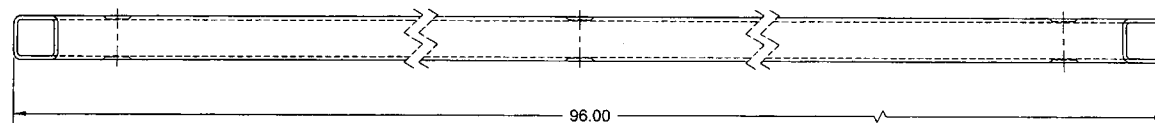
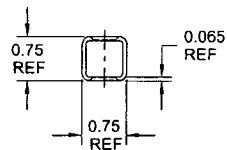
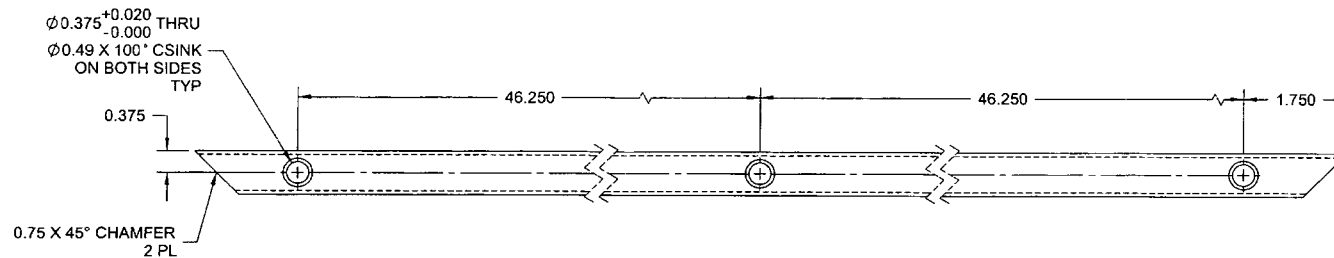
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D3827-1 RIB

RELEASED
08/11/14

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.55 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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